

WORK INSTRUCTION		
Title: Replacement of Miscellaneous Parts Not Requiring Detailed Instructions		
Instruction No. CH.03	Rev. 0.4, February 2006	Page 1 of 3
Approved for Use by: <u>Michael R. Brown</u> Effective Date: <u>February 2006</u>		
Applicable Drawings: <ul style="list-style-type: none">• 2077-500SNP (Sheets 1 - 11) - TRUPACT-II Packaging SARP Drawings• 707-SAR (Sheets 1 - 12) - HalfPACT Packaging SARP Drawings		
SARP Requirements: <ul style="list-style-type: none">• None, spare parts will be replaced if damaged or as needed.		
Tools Required: <ul style="list-style-type: none">• 1-in. hex wrench• Calibrated torque wrench• Lift equipment• Lid support stands• Flat blade screwdriver (3/8-in. tip)• 5/8-in. hex wrench or socket• Stainless steel wire brush• #31 (0.120-in. diameter) drill bit• Center punch• 7/32-in. drill bit• Power drill		
Spare Parts Required: <ul style="list-style-type: none">• The spare parts are identified in the work instruction steps. All spare parts listed are controlled and shall be recorded on the Maintenance Record.		
Materials Required: <ul style="list-style-type: none">• Loctite™ #222 thread locking compound or equivalent• Nickel-bearing lubricant		
Safety Requirements: <ul style="list-style-type: none">• Safety will be observed in accordance with site requirements.		
Prerequisite Conditions: <ul style="list-style-type: none">• To replace OCA guide plates, the lid must be removed and set on the lid stand.• The component to be replaced has been removed and discarded.		
Instruction Steps: <ul style="list-style-type: none">• There is no requirement to replace components in sequence listed.• The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply.• The replacement of these parts shall be documented on a Maintenance Record.• This instruction is not required to be attached to the Maintenance Record but may be used as a checklist during performance of maintenance.		

Instruction No. CH.03	Rev. 0.4, February 2006	Page 2 of 3
<input type="checkbox"/> Annulus debris seal (optional)	(PN 2077-156-21) PO#	
<input type="checkbox"/> OCA burnout plug	(PN 2077-163-13) PO#	
	or (PN 2077-170-06) PO#	
<i>(Tighten flush with flange to within 1/8-in.)</i>		
<input type="checkbox"/> Fork lift pocket cover (right side)	(PN 2077-171-11) PO#	
<input type="checkbox"/> Fork lift pocket cover (left side)	(PN 2077-171-12) PO#	
1.0 The above-listed parts require no instructions for installation.		
<input type="checkbox"/> OCA guide plates (optional)	(PN 2077-163-11) PO#	
<input type="checkbox"/> OCA guide plate screws (optional)	(PN 2077-160-14) PO#	
1.0 Coat new screw threads with thread locking compound.		
2.0 Attach new plate, torque plate screws (2077-160-14) to 24 lb-in.		
<input type="checkbox"/> OCA lift pocket cover nut	(PN 2077-163-09) PO#	
<input type="checkbox"/> OCA lift pocket tubes	(PN 2077-163-02) PO#	
<input type="checkbox"/> OCA lift pocket cover	(PN 2077-163-06) PO#	
<input type="checkbox"/> OCA lift pocket cover clip	(PN 2077-163-10) PO#	
<input type="checkbox"/> OCA lift pocket cover screw	(PN 2077-163-08) PO#	
<input type="checkbox"/> OCA lift pocket cover lanyard	(PN 2077-163-07) PO#	
<input type="checkbox"/> OCA lift pocket cover fastener (tool holder)	(PN 2077-163-05) PO#	
<input type="checkbox"/> OCA lift pocket tube attachment screw		
	<i>(Torque to 40 - 50 lb-in.)</i>	(PN 2077-163-03) PO#
<input type="checkbox"/> OCA lift pocket tube washer	(PN 2077-163-04) PO#	
1.0 If new OCA lift pocket cover(s) are needed, drill 7/32-in. hole in center of cover.		
2.0 If cap screws are reusable or if new cap screws are used, thoroughly clean threads and coat with thread locking compound.		
3.0 Place new lift pocket tube in proper orientation.		
<input type="checkbox"/> ICV wiper O-ring holder drive screw		
 (PN 2077-180-11) PO#	
	or (PN 2077-180-11A)	
Remove damaged screw by drilling using a #31 drill bit (0.120-in. diameter) to a depth of no more than 0.375-in. in the seal flange. Use a punch and pilot drill hole to ensure centering of hole.		
1.0 Remove debris (drill cuttings) from hole.		
2.0 Install new #6 drive screw (PN 2077-180-11) or #8 drive screw (PN 2077-180-11A) into hole by tapping with hammer.		
<input type="checkbox"/> Fork lift pocket cover screws	(PN 2077-160-30) PO#	
<input type="checkbox"/> Fork lift pocket cover washer	(PN 2077-160-31) PO#	
1.0 Coat new screw threads with nickel bearing lubricant.		
2.0 Install new screw and torque to 75 - 82 lb-in.		

Verification Requirements:

- 1.0 Measuring and test equipment used is listed on the Maintenance Record.
- 2.0 Spare parts used are listed on the Maintenance Record.
- 3.0 Work performed is described on the Maintenance Record.
- 4.0 Work Instruction is listed on the Maintenance Record.